

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

2. The second step is to define the requirements. This involves determining what the system needs to do and what it must be able to handle.

3. The third step is to design the system. This includes creating a detailed plan of how the system will be built and how it will be tested.

4. The fourth step is to implement the system. This involves building the system according to the design and testing it to ensure it works as intended.

5. The fifth step is to maintain the system. This involves keeping the system up-to-date and ensuring it continues to work properly over time.

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**Stop**

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[illegible]

**Customer:**

Run Start



**Stop**

**Abstract**

|                 |                     |
|-----------------|---------------------|
| <b>Draw Nbr</b> | <b>Revision Nbr</b> |
| D3570           | Rev E               |

0.00

0.00

0.00

0.00

WB 10-5-1

(18)

HB 10-5-1

100



## Waterjet

FLOW CNC Waterjet

FLOW WATER JET

## Memo

1-Cut as per Dwg D3570

Dwg Rev:

Prog Rev:

\*\*\*GRAIN DIRECTION AS PER DWG\*\*\*

2-Deburr if necessary

110



QC

## Quality Control

QC2- Inspect parts off machine FAI/FAIB

## Memo



# Dart Aerospace Ltd

| W/O: 58460 |         | WORK ORDER CHANGES                    |    |         |     |                                     |                          |
|------------|---------|---------------------------------------|----|---------|-----|-------------------------------------|--------------------------|
| DATE       | STEP    | PROCEDURE CHANGE                      | By | Date    | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 10/5/11    | #<br>80 | Took QM x1 For QI inspection template | S  | 10/5/11 | x1  |                                     | S<br>10/5/11             |
|            |         |                                       |    |         |     |                                     |                          |

Part No: D3570-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Quality System Instruction 012

INSPECTION

Procedure Issue Date: 08.04.01 Issue No.: 13

ISSUE REVISION: J

| PAGE | PAGE<br>REV. | SUBJECT                     | DATE     | INITIAL | DQA |
|------|--------------|-----------------------------|----------|---------|-----|
| 1    | A            | No Change                   |          |         |     |
| 2    | J            | Revised issue revision page | 09.09.24 |         |     |
| 3    | A            | No Change                   |          |         |     |
| 4    | J            | Revised Section 4.1         | 09.09.24 |         |     |
| 5    | J            | Revised Section 4.1         | 09.09.24 |         |     |
| 6    | B            | No Change                   |          |         |     |
| 7    | A            | No Change                   |          |         |     |

# Work Order ID 58460

May 7, 2010 10:10:43 AM



Page 3

Item ID: D3570-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 07/05/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

17 BR 10-6-2

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:15 AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 7:45 AM

=> JH 10/06/08

17 Ø

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

17 BR 10-6-3



**Work Order ID 58460**

May 7, 2010 10:10:43 AM



Page 4

Item ID: D3570-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 07/05/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg &amp; Stock Location

245A

0.00



Packaging

Memo

0.00

Packaging

10-6-4 SF (17)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/07

MF

10-6-7

|                       |        |              |         |
|-----------------------|--------|--------------|---------|
| DART AEROSPACE LTD    |        | Work Order:  | 38460   |
| Description: Bracket  |        | Part Number: | D3570-2 |
| Inspection Dwg: D3570 | Rev: E | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.209            | +0.005/-0.001 | .209             | ✓      |        |                      |          |
| 0.359             | +/-0.010      | .357             | ✓      |        |                      |          |
| 0.557             | +/-0.010      | .555             | ✓      |        |                      |          |
| 1.943             | +/-0.010      | 1.944            | ✓      |        |                      |          |
| 2.141             | +/-0.010      | 2.138            | ✓      |        |                      |          |
| 2.50              | +/-0.030      | 2.505            | ✓      |        |                      |          |
| 4.75              | +/-0.030      | 4.755            | ✓      |        |                      |          |
| 0.311             | +/-0.010      | .311             | ✓      |        |                      |          |
| 0.533             | +/-0.010      | .534             | ✓      |        |                      |          |
| 1.717             | +/-0.010      | 1.718            | ✓      |        |                      |          |
| 1.939             | +/-0.010      | 1.940            | ✓      |        |                      |          |
| 2.25              | +/-0.030      | 2.258            | ✓      |        |                      |          |
| 0.125             | +/-0.010      | .122             | ✓      |        |                      |          |
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|-----------------|---------------|---------------------|-----|
| Measured by: IR | Audited by: C | Prototype Approval: | N/A |
| Date: 10-5-11   | Date: 10/5/11 | Date:               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 09.10.16 | New Issue | KJ         |          |

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RETURN TO

ENGINEERING

UNCONTROLLED COPY

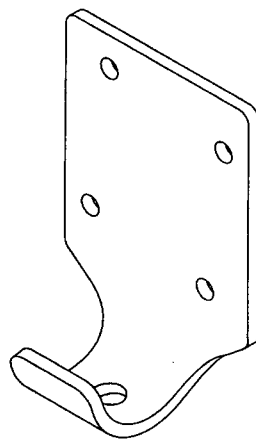
SUBJECT TO AMENDMENT

WITHOUT NOTICE

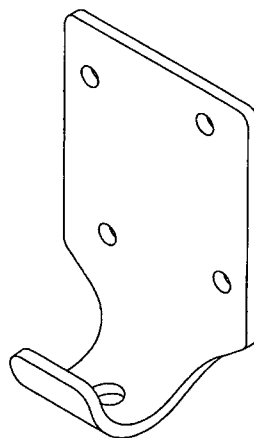
WORK ORDER

NO. 58460

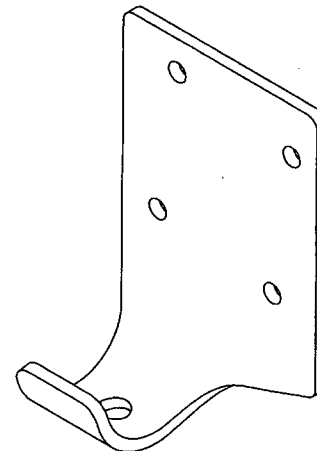
2010-5-07



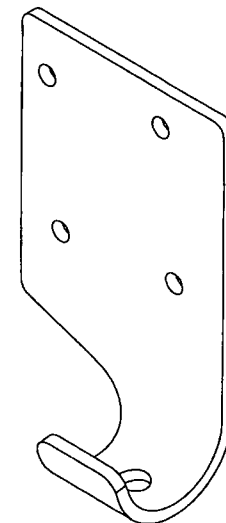
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

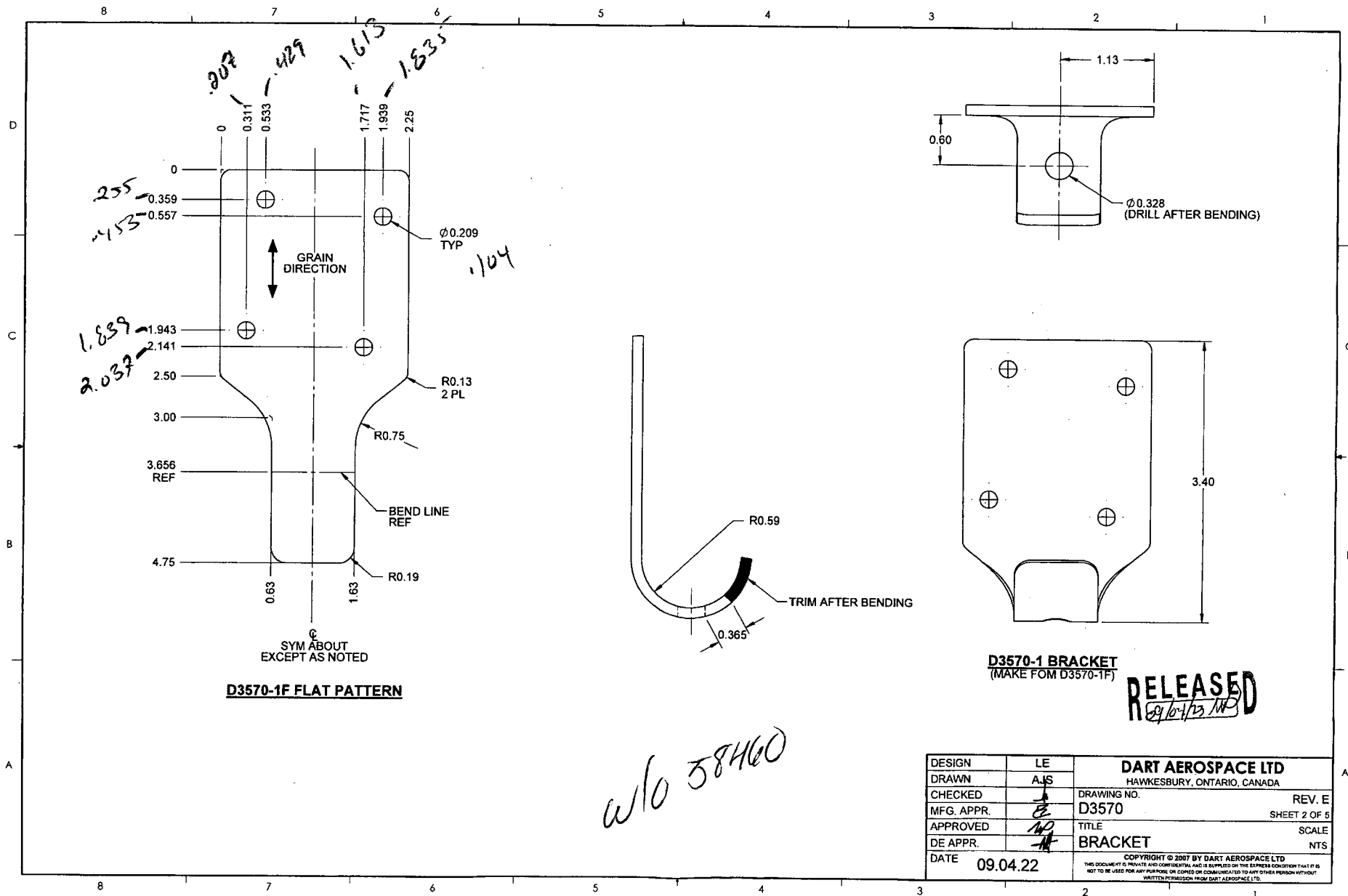
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09/04/22

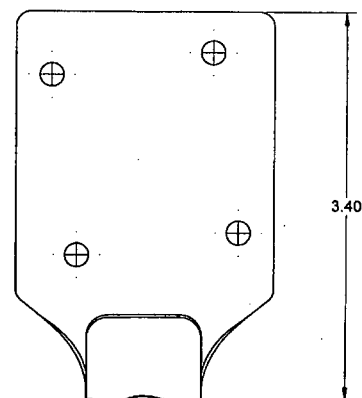
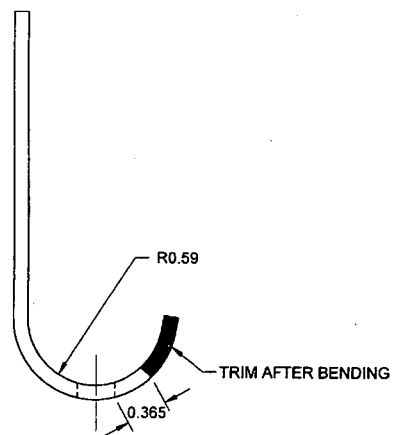
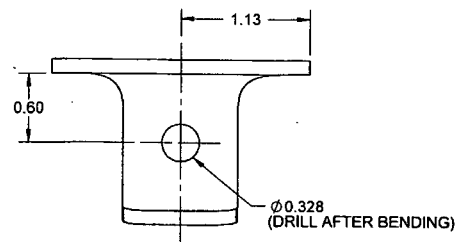
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEXT (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

| E          | SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014. | AJS  | 09.04.22     |
|------------|---|--|--------------|
| D          | ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.                             | AJS  | 09.04.01     |
| C          | UPDATE DIMS FOR CLARITY   | LE   | 07.06.01     |
| B          | CHANGE BEND RAD TO 0.60 FROM 0.50   | LE   | 07.04.16     |
| A          | NEW ISSUE   | LE   | 07.02.07     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | LE  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | AJS   |  |              |
| CHECKED    | <u>[Signature]</u>  | DRAWING NO.  | REV. E       |
| MFG. APPR. | <u>[Signature]</u>  | D3570  | SHEET 1 OF 5 |
| APPROVED   | <u>[Signature]</u>  | TITLE  | SCALE        |
| DE APPR.   | <u>[Signature]</u>  | BRACKET  | NTS          |
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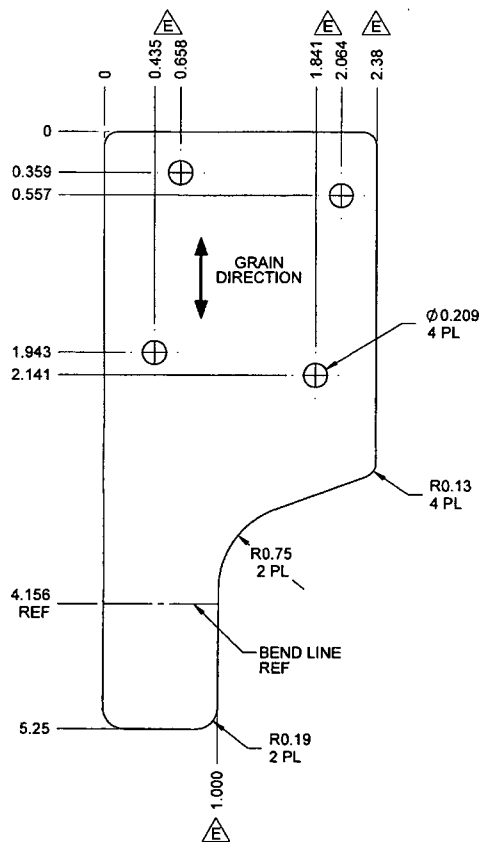


**D3570-2 BRACKET**  
(MAKE FROM D3570-1F)

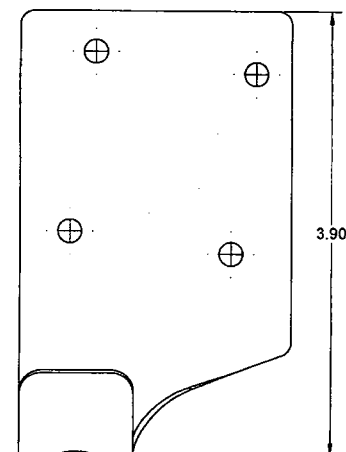
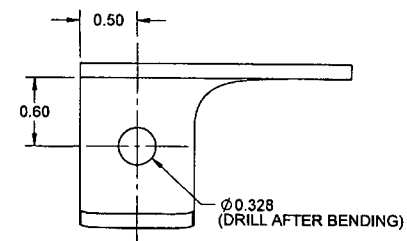
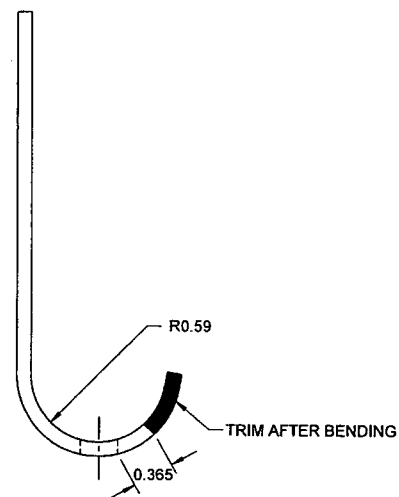
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| MFG. APPR. | <i>[Signature]</i> | D3570  | SHEET 3 OF 5 |
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**D3570-3F FLAT PATTERN**



**D3570-3 BRACKET**  
(MAKE FROM D3570-3F)

**RELEASED**  
07/24/23 MB

*col 58460*

|            |                    |  |              |
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| DRAWN      | AJS                |  |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.  | REV. E       |
| MFG. APPR. | <i>[Signature]</i> | D3570  | SHEET 4 OF 5 |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | BRACKET  | NTS          |
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